

Work Order ID 75866

75866

Page 1

Thursday, November 17, 2011 4:13:17 PM

Item ID: K10111

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/9/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-11-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9583

A

K10111

B

100

0.00

100

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP K10111 CHG003
FOR D206-642-111 CHG002
FOR D206-642-113 CHG002

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

Handwritten signature and date: 12-1-13

Handwritten circled number: 4

Handwritten signature: S. H. H.

Handwritten signature and date: 12/1/13

Handwritten circled number: 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75866

75866

Page 2

Thursday, November 17, 2011 4:13:17 PM

Item ID: K10111 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Skidtube 206
 Start Date: 11/1/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/9/2011 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		Sizlocks		(X4)			
130 *130* Packaging Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP K10111 PPP D206-642-111 PPP D206-642-113 Location: PK PPP rev: F	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

12/1/16 SP (4)
 12/1/17
 12-0214 (4)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Thursday, November 17, 2011 4:13:22 PM

Work Order ID: 75866

75866

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: F01.11.08 Revised Step 5 and Added Inspection Level

21SM

IPP REV:G

11.09.23 PER REV.B DD VERF:EC

IPP REV:H 11.11.14

AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-10A *AN5-10A* Bolt		Purchased	No				Each	872.0000	**	16			
<div>Location</div> <div>ST337 872</div> <div>116704 11</div> <div>118191 59</div> <div>119547 802</div> <div>Loc Qty</div> <div>Loc Code</div>													
AN5-11A *AN5-11A* Bolt		Purchased	No				Each	1,599.000	**	16			
<div>Location</div> <div>ST337 21</div> <div>117313 2</div> <div>118191 19</div> <div>ST518 1578</div> <div>119512 1578</div> <div>Loc Qty</div> <div>Loc Code</div>													
AN3-41A *AN3-41A* Bolt		Purchased	No			110	Each	1,655.000	**	32			
<div>Location</div> <div>st510 1655</div> <div>119042 1655</div> <div>Loc Qty</div> <div>Loc Code</div>													

12/1/13 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Thursday, November 17, 2011 4:13:22 PM

Work Order ID: 75866

75866

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-6A Purchased No

110 Each 5,062.000 12 48

AN4-6A

Bolt

**

Location

Loc Qty

Loc Code

ST356

62

119127

62

ST516

5000

119017

5000

AN4C5A Purchased No

110 Each 489.0000 1 4

AN4C5A

BOLT

**

Location

Loc Qty

Loc Code

FP-B

49

112243

49

ST355

440

112243

340

119017

100

AN6-44A Purchased No

110 Each 511.0000 2 8

AN6-44A

Bolt

**

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

504

119036

504

D206-651-041 Manufactured No

110 Each 1.0000 1 4

D206-651-041

206A/B GHW

**

Location

Loc Qty

Loc Code

FG125

1

74002

1

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Thursday, November 17, 2011 4:13:22 PM

Work Order ID: 75866

75866

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2652

Manufactured No

110 Each

743.0000 16 64

D2652

Bushing

**

B76133

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

699

73835

579

73836

120

D2661-1

Manufactured No

110 Each

18.0000 2 8

D2661-1

Saddle, LH Fwd Aft Out 206

**

B76808

Location

Loc Qty

Loc Code

MEZZ

5

64559

5

ST435

13

73838

10

73841

1

76516

2

D2662-1

Manufactured No

110 Each

20.0000 2 8

D2662-1

Saddle, LH In 206

**

B76784

B76808

Location

Loc Qty

Loc Code

ST435

10

73846

1

74479

9

ST476

10

74481

10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, November 17, 2011 4:13:22 PM

Work Order ID: 75866

75866

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2712

Manufactured No

110 Each

2,551.000 10 40

**

D2712

Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

2501

71160

1

73837

500

76065

2000

D2884

Manufactured No

110 Each

100.0000 2 8

**

D2884

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29453

10

ST025

90

73823

90

D2885

Manufactured No

110 Each

126.0000 2 8

**

D2885

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29199

10

ST025

116

73824

116

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Thursday, November 17, 2011 4:13:22 PM

Work Order ID: 75866

75866

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D3413-1

Manufactured No

110

Each

94.0000

1

4

**

B75478

D3413-1

Ring

Location

Loc Qty

Loc Code

ST368

2

73821

2

ST420

2

66387

1

70773

1

ST469

88

73822

88

ST473

2

71041

2

MS21042L3

Purchased No

110

Each

8,781.000

8

32

**

12/1/13

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2526

119075

2526

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Thursday, November 17, 2011 4:13:22 PM

Work Order ID: 75866

75866

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

110

Each

11,520.00

12

48

MS21042L 4

Nut

Location

Loc Qty

Loc Code

ST300

558

117441

51

117601

374

118451

133

ST516

5962

119017

5962

ST518

5000

119075

5000

MS21042L6

Purchased

No

110

Each

1,484.000

2

8

MS21042L 6

Nut

Location

Loc Qty

Loc Code

ST300

484

117677

25

118384

5

118927

48

118968

406

ST518

1000

119075

1000

NAS1149C0463R

Purchased

No

110

Each

1,379.000

1

4

NAS1149C0463R

Washer

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1378

117735

378

119097

1000

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Thursday, November 17, 2011 4:13:22 PM

Work Order ID: 75866

75866

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

4,466.000

8

32

NAS1149D0363.I

Washer

**

M120142

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1450

117601

148

118077

1

118612

55

118968

1246

NAS1149D0463J

Purchased

No

110

Each

12,710.00

24

96

NAS1149D0463.I

Washer

**

12/1/12

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12386

119075

10000

119097

2386

96

Thursday, November 17, 2011 4:13:22 PM

Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Thursday, November 17, 2011 4:13:22 PM

Work Order ID: 75866

75866

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

5,153.000

- 8

32

**

NAS1149D0563.I

Washer

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3153

118206

2153

118614

1000

NAS1149D0663J

Purchased

No

110

Each

2,598.000

4

16

**

NAS1149D0663.I

Washer

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Change Record

Part Number D206-642-111
Description 206 SKIDPODE INSTALLATION

Page 1 of

[illegible]

REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	K10111	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE KIT	NTS
DATE	11.11.10	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	